

In order that the work may be quickly inserted and removed, the jig is made in halves. As the illustration shows, these halves are hinged at the left and held together for the drilling by a latch that appears at the right of the illustration. The drill bushings are located in the faces of the halves of the jig. After the holes in one flange of the hub have been drilled, the steel plate that takes the thrust is removed from beneath

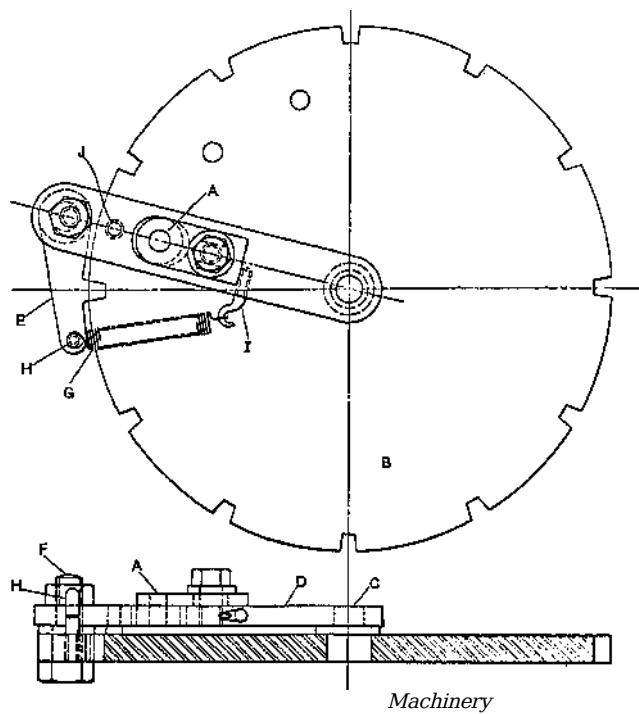


Fig. 35. Jig for Drilling Holes in Power Press Dial Plates

the work. Then by withdrawing the index-pin at the left, the working part of the jig can be turned 180 degrees to present the other face of the hub to the drills. The heavy stud on which the jig swivels is directly behind the work,

and, therefore, not visible in the illustration. The index-pin is inserted, the thrust plate is replaced, and the drilling of the hub is completed. The hubs, each having 32 holes — 16 in each end — are drilled at the rate of 300 per ten-hour day.